

AMENDMENT TO THE CLAIMS

1. (Currently Amended) A method for producing a cover ~~made of a special steel blank which can be deep-drawn and placed on~~ for an end of a motor vehicle exhaust pipe, the method steps directly following each other and including:

a) making a circular blank (10) from a steel plate,

b) drawing in a plurality of deep-drawing operations a plurality of cup-shaped beakers (10.1, 10.2, 10.3, 10.4) each with a bottom (11.4) inclined with respect to a longitudinal axis (25), and having diameters (D1, D2, D3, D4) that are uniform over an entire ~~shell~~ length (L1, L2, L3, L4) of a shell (12.4), but are ~~more and more~~ decreased and the shell lengths (L1, L2, L3, L4)[[.]] are ~~more and more~~ increased upon each of the deep drawing operations, resulting in a beaker with a bottom (11.4) inclined with respect to a longitudinal axis (25),

c) punching a centered hole (13) through ~~into~~ the bottom (11.4) a ~~centered hole (13) with~~ of the beaker and leaving a rim (14) which is ring-shaped ~~toward a~~ around the hole (13) and between the hole (13) and the shell (12.4),

d) cutting the shell (12.4) vertically with respect to the longitudinal axis (25) of the beaker (~~10.4~~) to a required length (Lo) and cutting a condensate drain opening (16) and a fastening hole into the shell (~~12.5~~),

e) bending the rim (14) of the bottom (11.4) parallel with respect to the longitudinal axis (25) and subsequently crimping into the beaker (~~10.6~~) to form an end (17) shaped as an arc of a circle, and

f) tapering an end section (18) on the cut open front (15) of the beaker (~~10.7~~) for decreasing the diameter.

2. (Currently Amended) The method in accordance with claim 1, wherein a transition from the inclined bottom (~~11.1 to 11.6~~) to the shell (~~12.1 to 12.5~~) of the deep-drawing operations is rounded.

3. (Currently Amended) The method in accordance with claim 2, wherein the bottom (~~11.1 to 11.6~~) with respect to the shell (~~12.1 to 12.5~~) of the deep-drawing operations is inclined ~~on a diameter of~~ approximately 70° or 110° relative to the longitudinal axis (25).

4. (Previously Presented) The method in accordance with claim 3, wherein cutting off the shell (12.4) to the required length (Lo) and cutting at least one of the condensate drain opening (16) and the fastening hole are performed together.

5. (Currently Amended) The method in accordance with claim 4, wherein the ~~bore~~ hole (13) in the bottom (~~11.5~~) is shaved (~~13.1~~) prior to crimping the end (15) in the shape of the arc of the circle.

6. (Currently Amended) A cover, produced in accordance with the method of claim 5, crimped in the shape of the arc of the circle, wherein an other front face (15) which extends perpendicularly with respect to the longitudinal axis (25) in an adjoining section (18) has a diameter smaller than the diameter (D4) of the remaining shell (12.4).

7. (Previously Presented) A cover, produced in accordance with the method of claim 1, crimped in the shape of the arc of the circle, wherein an other front face (15) which extends perpendicularly with respect to the longitudinal

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axis (25) in an adjoining section (18) has a diameter smaller than the diameter (D4) of the remaining shell (12.4).

8. (Currently Amended) The method in accordance with claim 1, wherein the bottom (~~11.1 to 11.6~~) with respect to the shell (~~12.1 to 12.5~~) of the deep-drawing operations is inclined ~~on a diameter of~~ approximately 70° or 110° relative to the longitudinal axis (25).

9. (Previously Presented) The method in accordance with claim 1, wherein cutting off the shell (12.4) to the required length (Lo) and cutting at least one of the condensate drain opening (16) and the fastening hole are performed together.

10. (Currently Amended) The method in accordance with claim 1, wherein the ~~bore~~ hole (13) in the bottom (~~11.5~~) is shaved (~~13.1~~) prior to crimping the end (15) in the shape of the arc of the circle.

11. (New) A method for producing a cover for an end of a motor vehicle exhaust pipe, the method steps directly following each other and including:

- a) providing a circular blank from a steel plate;
- b) drawing from the circular blank in a plurality of deep-drawing operations a cup-shaped beaker with a bottom inclined with respect to a longitudinal axis of the beaker, the beaker having a diameter that is uniform over an entire length of a shell extending from an outer edge of the bottom and parallel to the longitudinal axis;
- c) punching a centered hole through the bottom of the beaker and leaving a ring-shaped rim around the hole and between the hole and the shell;
- d) cutting the shell to a required length and cutting at least one of a condensate drain opening or a fastening hole into the shell;
- e) bending the rim of the bottom in a direction toward the inside surface of the shell to form an end shaped as an arc of a circle; and
- f) tapering an end section of the beaker that is opposite the end shaped as an arc of a circle.

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12. (New) The method in accordance with claim 11, wherein each subsequent operation of the plurality of deep-drawing operations comprises a decreasing of a diameter of the shell and a corresponding increasing of a length of the shell.